

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Friday, May 05, 2017 11:49:29 AM

Page 2

Item ID:	D4931-5	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Engine Fitting (for B3e models)				Stop	*NS2*
Start Date:	5/15/2017	Start Qty:	8.00	*8*		
Required Date:	5/23/2017	Req'd Qty:	8.00	*8*		
Reference:	(P.A.)SCHEDULED/S			Cust Item ID:		
				Customer:		

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 160976

Friday, May 05, 2017 11:49:29 AM

160976

Page 3

Item ID: D4931-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Engine Fitting (for B3e models)
Start Date: 5/15/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 5/23/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: SH36	0.00							
130									
Packaging	Memo	0.08				6		DAS JUN 15 2017	
Packaging								9-89	
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.80							17/6/19
Quality Control									

DAS
21
9-89

JUN 15 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, May 05, 2017 11:49:29 AM

Page 1

Work Order ID: 160976

160976

Parent Item: D4931-5

D4931-5

Parent Item Name: Engine Fitting (for B3e models)

Start Date: 5/15/2017

Required Date: 5/23/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303R2.000		Purchased	No			100	f	16.8530	0.15	1.263158			
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M303R2 000

**

303 ROUND BAR 2"

Location

Loc Qty

Loc Code

MAT028

16.853

m136463

12

m136468

4.853

1.8

DAS

45

9-89

2017-6-7

251/2 p +

DQA: _____ Date: _____

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Work Order update only ☐

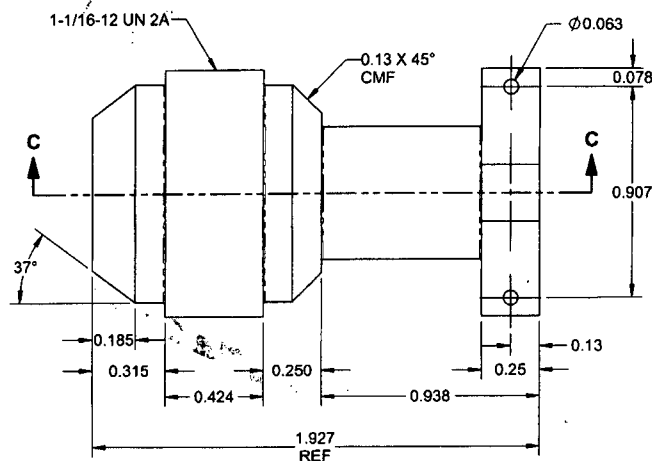
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER :																																																																							

DART AEROSPACE LTD		Work Order: 160976
Description: EAPS P2 Engine Fitting		Part Number: D4931-5
Inspection Dwg: D4931	Rev: A	Page 1 of 1

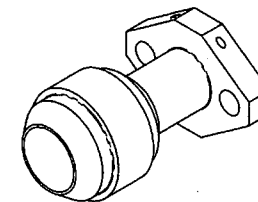
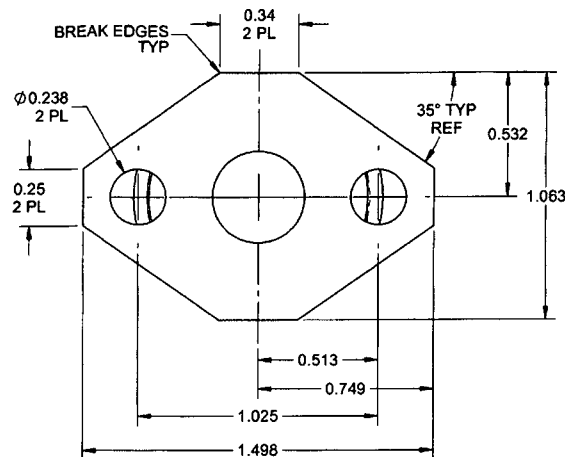
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	N/A	✓	✓			
37°	+/-0.5°	37°	✓			
0.185	+/-0.010	.185	✓		VERP	SL-10
0.315	+/-0.010	.315	✓			
0.424	+/-0.010	.424	✓			
0.250	+/-0.010	.250	✓			
0.938	+/-0.010	0.937	✓			
1.927 Ref	+/-0.010	1.922	✓			
0.25	+/-0.030	0.246	✓			
0.13	+/-0.030	0.125	✓			
0.907	+/-0.010	.906	✓			
0.078	+/-0.010	.080	✓			
Ø0.063	+0.004/-0.001	.063	✓			
0.13 x 45°	+/-0.030 x +/-0.5°	.13 x 45°	✓			
0.34	+/-0.030	.345	✓			
0.25	+/-0.030	.250	✓			
Ø0.238	+0.005/-0.001	0.238	✓		Caliper	JCL-08
35°	+/-0.5°	35°	✓			
0.532	+/-0.010	.534	✓			
1.063	+/-0.010	1.063	✓			
0.513	+/-0.010	0.513	✓		Caliper	JCL-08
0.749	+/-0.010	.750	✓			
1.025	+/-0.010	1.025	✓		Caliper	JCL-08
0.609	+0.008/-0.001	0.612	✓			
Ø.394		.395	✓			
.938	+0/-0.005	.936	✓			
.571	DAS ±.010	.568	✓			

Measured by: 45 SL 9-89	Audited by: L.A. 08 9-89	Preliminary Approval:
Date: 2017-6-7	Date: 17-06-13	Date:
Rev	Date	Change
A	14.06.24	New Issue
Revised by: KJ		Approved:



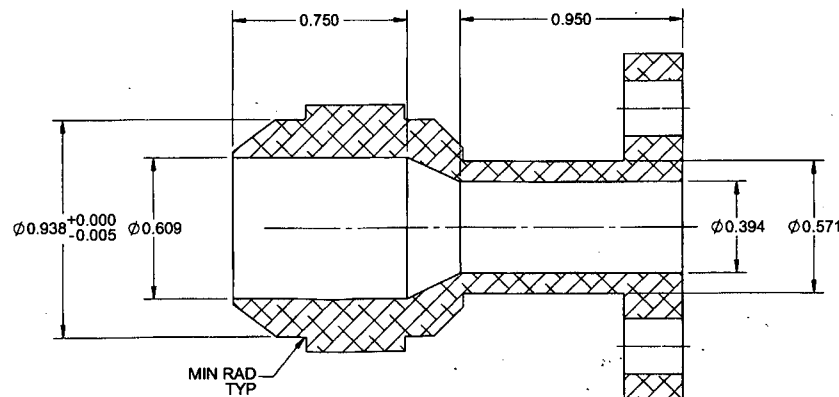
D4931-5 EAPS P2 ENGINE FITTING
(FOR B3 MODELS WITH ARRIEL 2D ENGINES)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO.
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 100970

PA-20170523

RELEASED
2014-01-08



SECTION C-C

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	47	DRAWING NO.	REV. A
MFG. APPR.	47	D4931	SHEET 3 OF 3
APPROVED	47	TITLE	SCALE
DE APPR.	47	EAPS P2 ENGINE FITTING	
DATE	13.09.20	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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